

Date: Monday, 11/6/2006 2:39:57 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
 Job Number : 29343
 Estimate Number : 10832
 P.O. Number : *N/A* Part Number : D29322
 This Issue : 11/6/2006 S.O. No. : *N/A* Drawing Number : D2932 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 29231 Material : *N/A*
 Due Date : 11/24/2006 Qty: *10* Um: *8* Each,
 Written By : *[Signature]*
 Checked & Approved By : *[Signature] 06.11.06*
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

B25346 x 2

Grain Along Long 7.88 Length

Batch No *B25348 x 8*

J.F. 06/11/13

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1.

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

SD/J.F. 06/11/13

(10)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SD 06.11.13

(10)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



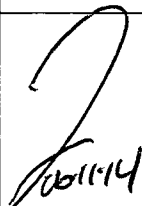
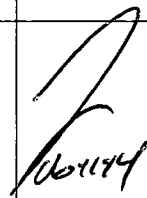
Comment: INSPECT ALL DIM TO DIM SHEET

SD 06.11.14

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.11.07	2	TOOL RAD IN FLANGE POCKETING IS R0.188 INSTEAD OF R0.25	CP 06.11.07 per QSI/AR	USE R0.188 TOOL FOR FLANGE POCKETING AS MARKED UP ON DWG	SD 06.11.14	 06.11.14	CP 06.11.07 per QSI/AR	 06.11.14

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 29343

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

gml 06/11/22

10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a-n 06/11/29

(10X)

7.0

POWDER COATING

POWDER COATING



M 102 3a1



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h/ 06/12/19

(10X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/12/20

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57472*

06/12/20

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/20

Job Completion



06/12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 29343
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125"	.119	.119	.119		
B	0.100	0.140		.125"	.118	.118	.118		
C	0.100	0.140		.115"	.118	.116	.116		
D	0.210	0.230		.224"	.224	.221	.228		
E	1.245	1.255		1.252"	1.25	1.258	1.250		
F	1.245	1.255		1.251"	1.250	1.250	1.251		
G	2.495	2.505		2.502"	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.582"	1.578	1.577	1.578		
J	2.495	2.505		2.501"	2.501	2.501	2.501		
K	0.257	0.262	DT8683	.258"	.258	.258	.258		
L	0.312	0.317	DT8686	.314"	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.119"	.122	.120	.127		
O	0.540	0.560		.545"	.550	.548	.551		
P	0.490	0.510		.504"	.501	.501	.508		
Q	3.715	3.725		3.719"	3.720	3.720	3.721		
R	2.470	2.510		2.495"	2.493	2.493	2.488		
S	0.240	0.270		.252"	.250	.251	.249		
T	0.100	0.180		.140"	.140	.140	.140		
U	1.625	1.635		1.632"	1.630	1.630	1.630		
V	1.362	1.372		1.371"	1.367	1.364	1.366		
W	0.316	0.321	DT8690	.319"	.319	.319	.319		
X	1.125	1.145		1.134"	1.139	1.137	1.144		
Y	1.565	1.585		1.575"	1.577	1.575	1.582		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F.	SD
Date: 06/11/13	06.11.14

Audited by: Jnl	
Date: 06/11/22	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD	Work Order:	29343
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.125	.124	.126		
B	0.100	0.140		.123	.124	.127	.124		
C	0.100	0.140		.123	.118	.122	.123		
D	0.210	0.230		.228	.227	.227	.226		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.501	2.501	2.501		
K	0.257	0.262	DT8683	.258	.258	.256	.258		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.126	.120	.120	.120		
O	0.540	0.560		.553	.552	.551	.557		
P	0.490	0.510		.490	.493	.499	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.493	2.493	2.493	2.493		
S	0.240	0.270		.256	.260	.259	.257		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.620	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.319	.319	.319	.319		
X	1.125	1.145		1.134	1.134	1.134	1.134		
Y	1.565	1.585		1.574	1.574	1.574	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.11.14

Audited by:	mt
Date:	06/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD	Work Order: 29343
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. B	Page 1 of 1

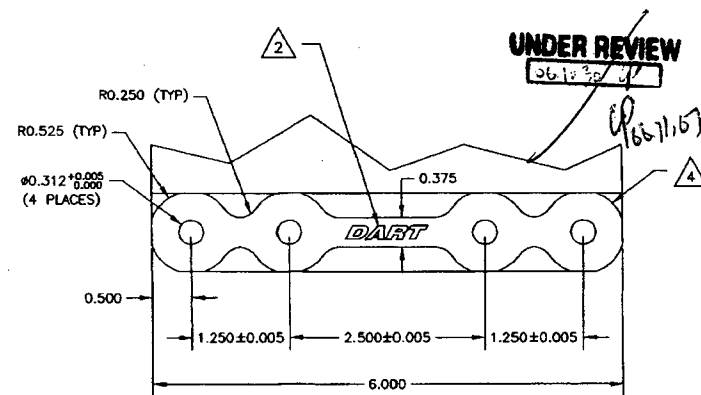
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.124	.124				
B	0.100	0.140		.124	.124				
C	0.100	0.140		.122	.123				
D	0.210	0.230		.226	.226				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.501	2.501				
H	0.510	0.515		.514	.514				
I	1.572	1.582		1.578	1.574				
J	2.495	2.505		2.498	2.501				
K	0.257	0.262	DT8683	.258	.258				
L	0.312	0.317	DT8686	.314	.314				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.120	.120				
O	0.540	0.560		.552	.552				
P	0.490	0.510		.500	.498				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.493	2.493				
S	0.240	0.270		.257	.257				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.364	1.364				
W	0.316	0.321	DT8690	.319	.319				
X	1.125	1.145		1.134	1.135				
Y	1.565	1.585		1.574	1.575				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

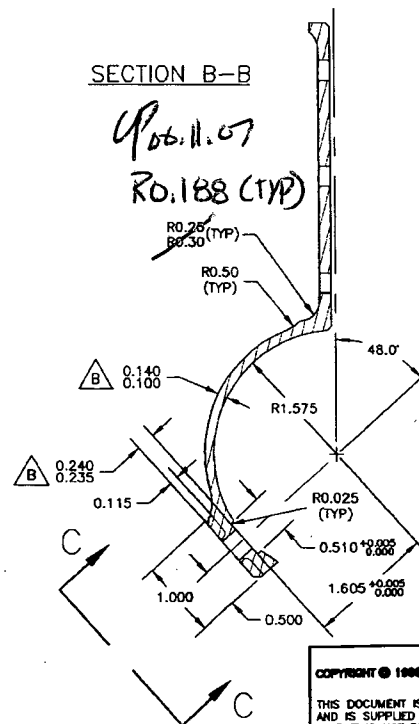
Measured by: <i>SD</i>
Date: 06.11.14

Audited by: <i>ml</i>
Date: 06/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF <i>[initials]</i>	<i>[initials]</i>






SECTION B-B



- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASE
00.05.31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN 	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED 	APPROVED 	DRAWING NO. D2932 REV. E SHEET 1 OF 2
DATE 00.05.29		TITLE SADDLE OUTSIDE

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WITHOUT NOTICE
WORK ORDER
NO. 29343

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006